

Work Order ID 84740-1

Tuesday, May 22, 2012 1:05:32 PM

Split

84740

Ship Friday Page 1

Item ID: D212-725-1-929

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: HOUSING ASS'Y

Start Date: 5/22/2012 Start Qty: 10.00

10

Required Date: 5/25/2012 Req'd Qty: 10.00

10

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-725-1	Rev F								

100

100

Purchasing

Purchasing

Memo

Issue P/O: _____
E-mail or Ship electronic file and or dwg to vendor to
manufacture the following:
qty 1 D212-725-1-147

Manufacture as per Dwg and supplied files
Possible supplier: Sieg's
Material release note is required

0.00

0.00

0.00

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Qrs

0.00

Memo

A

0.00

N
A
see WO
52709, casted at 1/2
PO WO was MF
12-05-22

*WAS already
inspected on
w/ 052709
MF*

*12-05-22
see attached*

Work Order ID 84740

Tuesday, May 22, 2012 1:05:32 PM

Item ID: D212-725-1-929

Revision ID:

Item Name: HOUSING ASS'Y

Start Date: 5/22/2012 Start Qty: 10.00

Accept

84740***N900040100***

Setup Start

NS1

Required Date: 5/25/2012 Req'd Qty: 10.00

10***10***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID:

120

120

QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Memo

Set Up/
Run Hours0.00
0.00-50709

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 114509

0.00

Memo

(6)

0

2 25-23 pto

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

(5)

n 12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-5-23	130	part was scrapped taking it out of sag		Script + Dasty at 2x1 No replace - APPLY ANISIZE To help remove part from sag	EL 12-5-23	✓ 12-05-23		

NOTE: Date & initial all entries

Work Order ID 84740

Tuesday, May 22, 2012 1:05:32 PM

84740

Page 3

Item ID: D212-725-1-929

Accept

Revision ID:

Item Name: HOUSING ASS'Y

Start Date: 5/22/2012 Start Qty: 10.00

10

Required Date: 5/25/2012 Req'd Qty: 10.00

10

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center ID

150

150

QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

6x

Cx.05.23

160

160

Packaging

Packaging

Identify as per dwg & Stock Location:

38

0.00

50

12/28/09

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

MWS 12/05/12

Picklist Print

Tuesday, May 22, 2012 1:05:31 PM

Page 1

Work Order ID: 84740

Parent Item: D212-725-1-929

Parent Item Name: HOUSING ASS'Y

Start Date: 5/22/2012

Required Date: 5/25/2012

Comments: IPP Rev:A08-03-11 New Issue DD verified by:LL

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D212-725-1-143

Base Plate

Manufactured

No

Each 4.0000

52702- MFC 12-05-22

Location	Loc Qty	Loc Code
ST367	4	

52702

Each

10.0000

10

D212-725-1-145

Tube

Manufactured

No

Each 10.0000

10

52702- MFC 12-05-22

Location	Loc Qty	Loc Code
ST366	10	

52705

Each 0.0000

10

D212-725-1-147P

Cup

Purchased

No

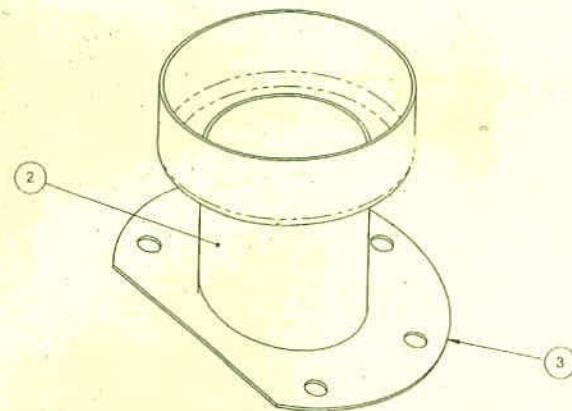
Location	Loc Qty	Loc Code
ST366	10	

52705

Each 0.0000

52709 MFC 12-05-22

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D212-725-1-929	HOUSING ASSEMBLY
2	1	D212-725-1-145	TUBING
3	1	D212-725-1-143	BASE PLATE
4	1	D212-725-1-147	CUP



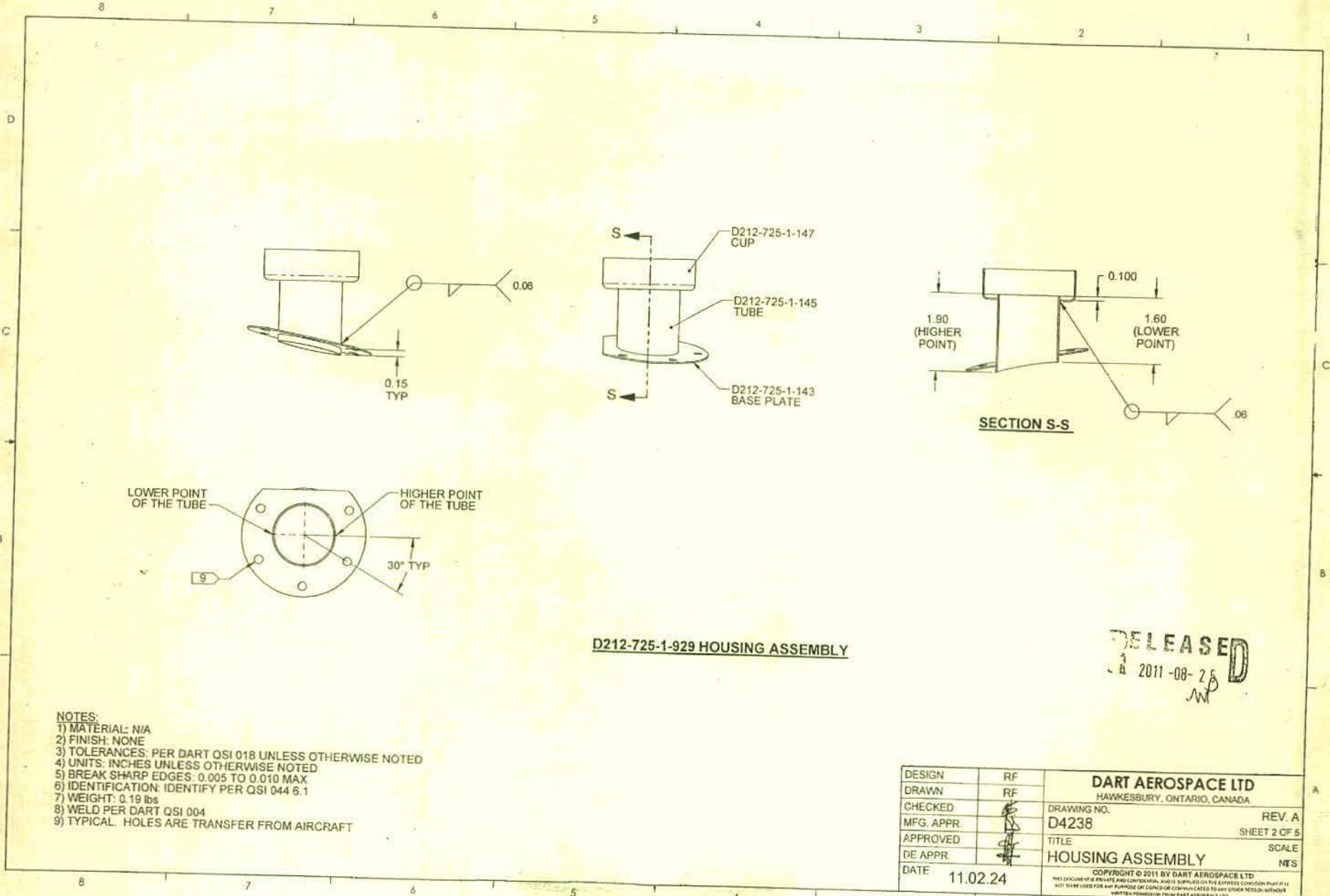
D212-725-1-929 HOUSING ASSEMBLY

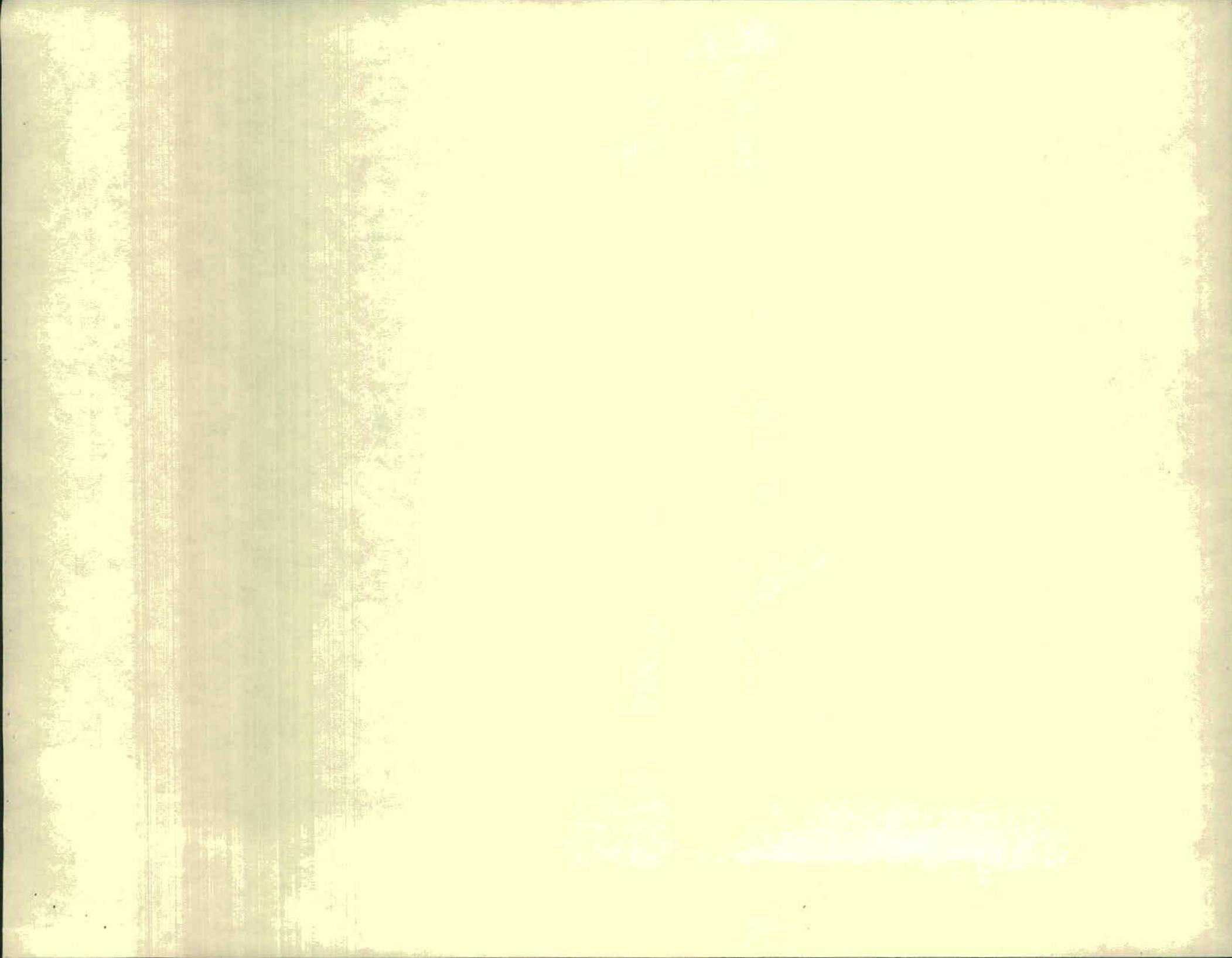
NOTES:

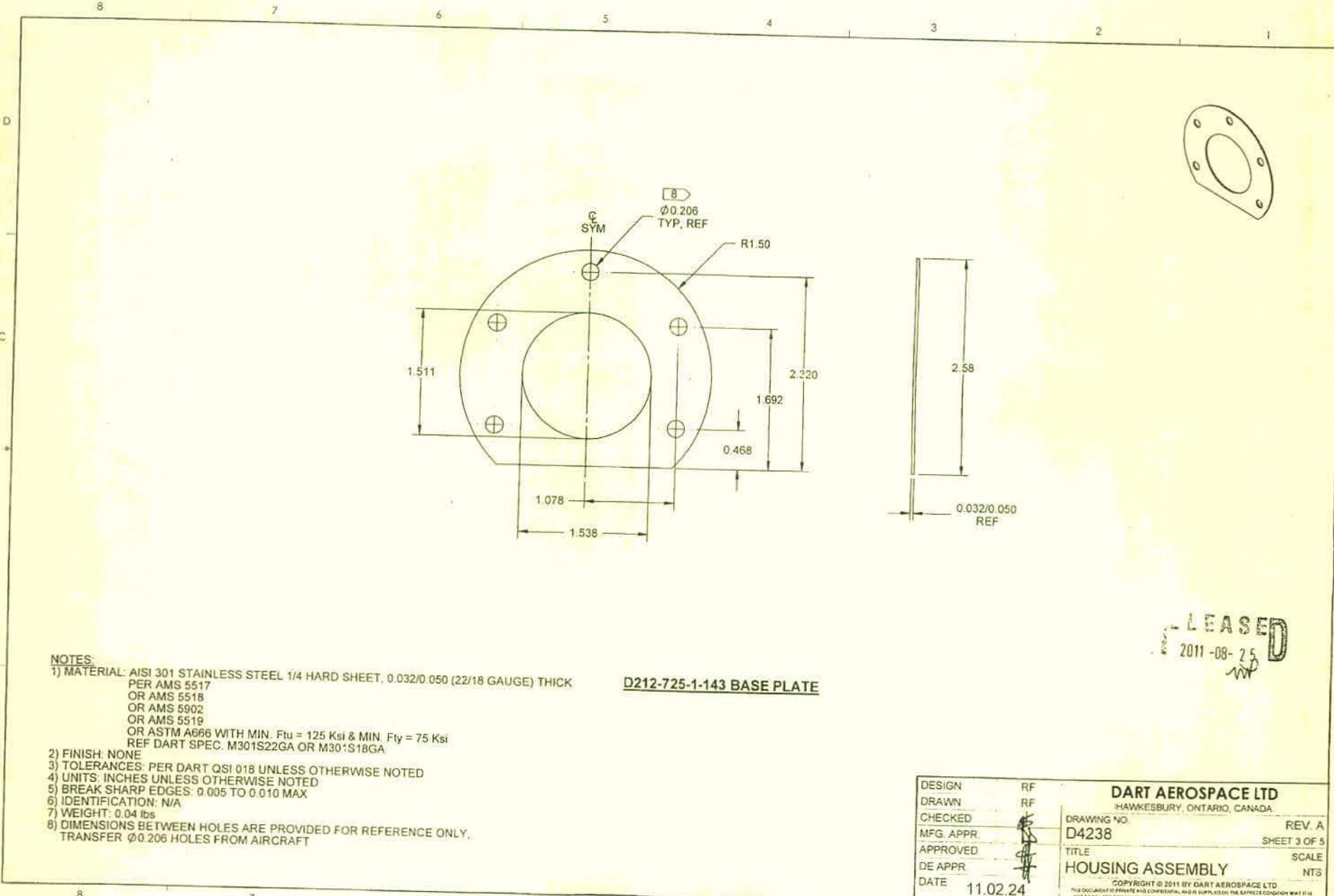
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.19 lbs

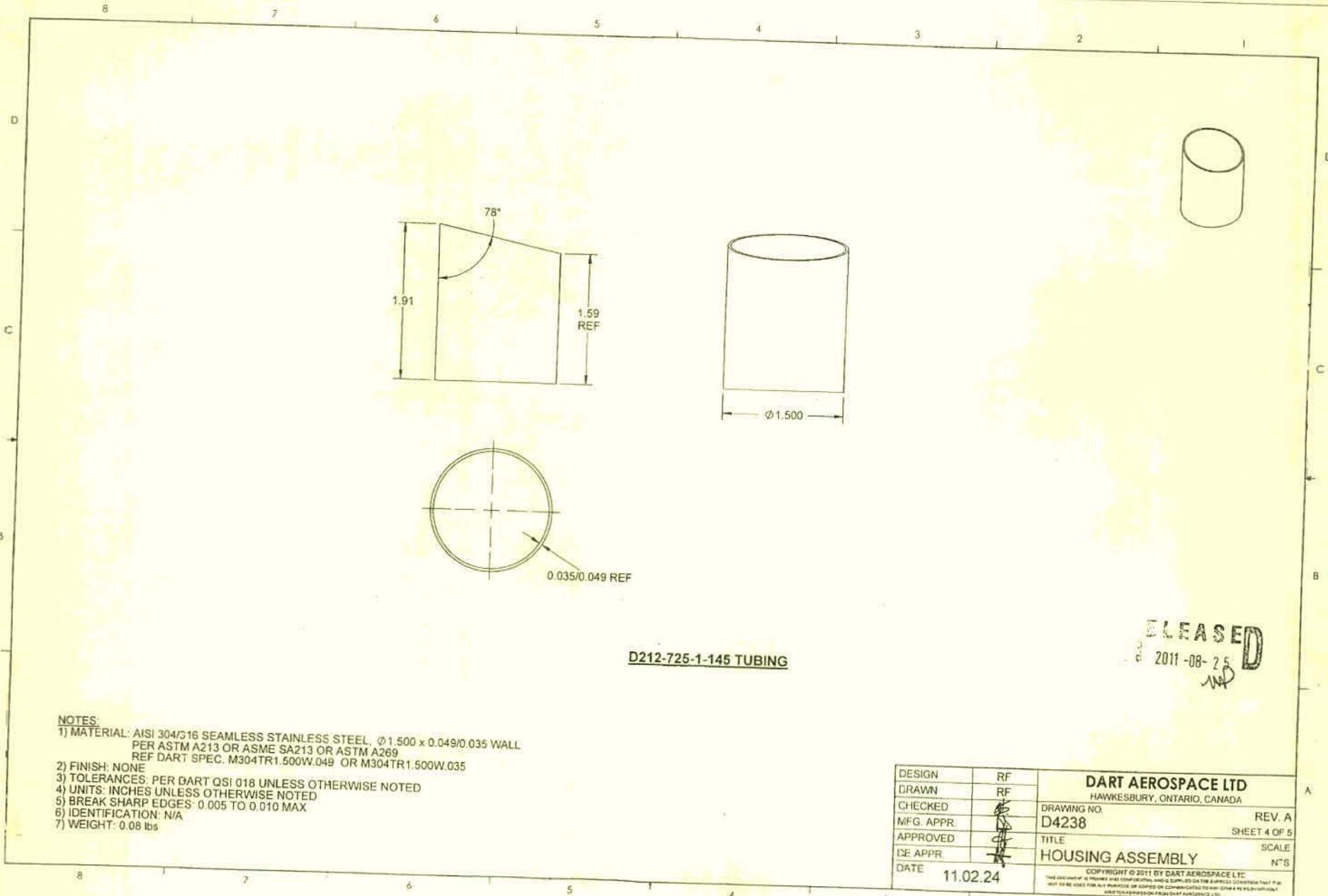
REV	NEW ISSUE		RF	11.02.24
DESIGN	RF	DART AEROSPACE LTD		BY DATE
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D4238	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		HOUSING ASSEMBLY	NTS	
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD		
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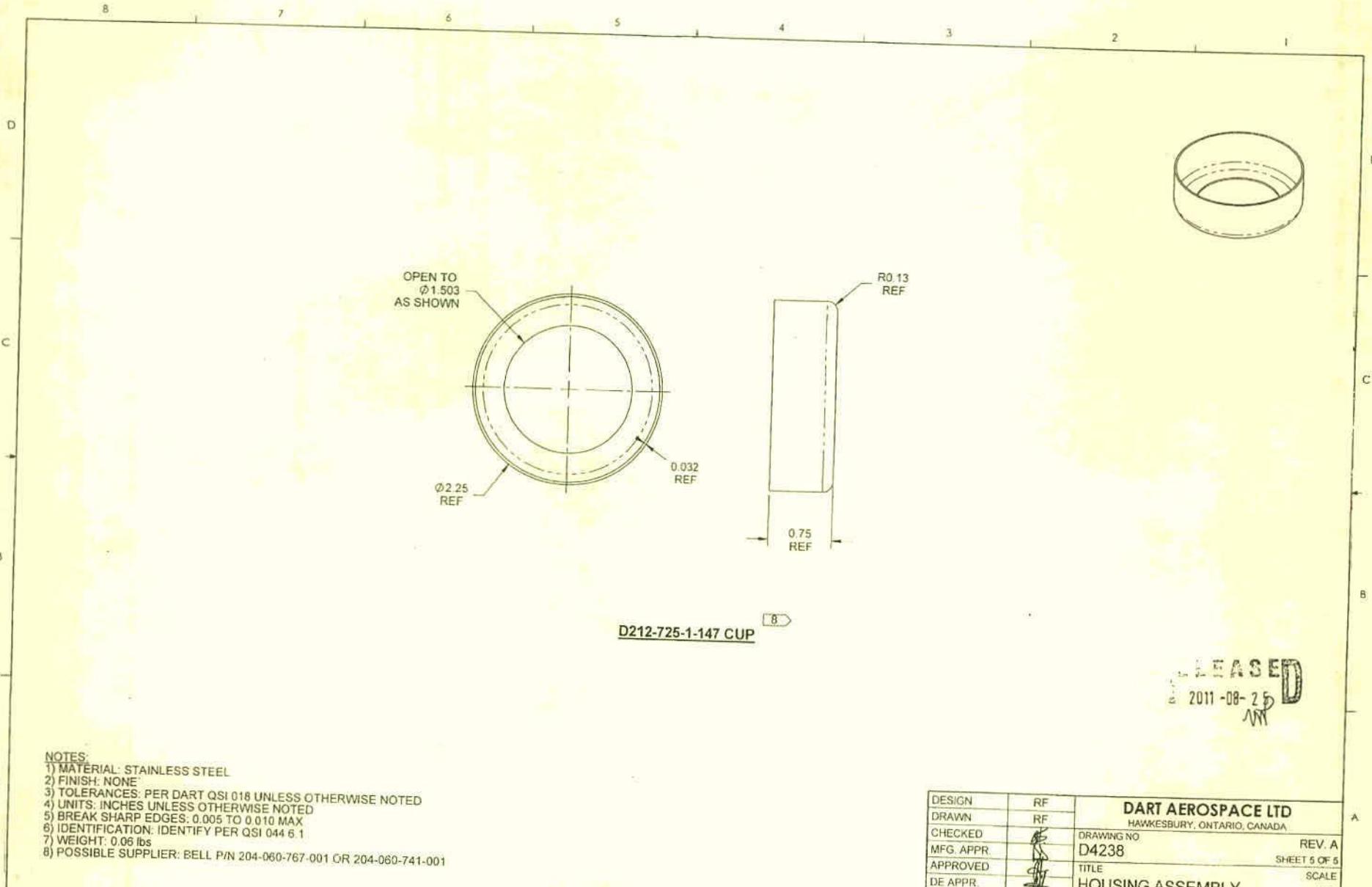
RELEASED
2011-08-25
M/S











RELEASED 2011-08-25

DESIGN	RF	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.			
MFG. APPR.		D4238			
APPROVED		REV. A			
DE APPR.		SHEET 5 OF 5			
DATE	11.02.24	SCALE			
		NTS			
HOUSING ASSEMBLY					
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REFERENCE ONLY

Work Order ID 52709

October 8, 2009 10:24:37 AM



Page 1

Item ID: D212-725-1-929

Accept



Setup Start



Revision ID: B

Stop



Item Name: HOUSING ASS'Y

Start Date: 10/08/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/08/09 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D212-725-1	Rev B
------------	-------

100



Purchasing

Purchasing

Memo

0.00

Issue P/O: 10/08/09
E-mail or Ship electronic file and or dwg to vendor to
manufacture the following:
qty 10 D212-725-1-147

Manufacture as per Dwg and supplied files
Possible supplier: Sieg's
Material release note is required

110



Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Packaging

Memo

0.00

Work Order ID 52709

October 8, 2009 10:24:37 AM



Page 2

Item ID: D212-725-1-929

Accept



Setup Start



Revision ID: B

Item Name: HOUSING ASS'Y

Stop



Start Date: 10/08/09 Start Qty: 10.00



Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC6- Inspect dimensions to drawing

Set Up/
Run Hours

0.00

Draw
Number

8067/27

Draw
Rev.

1

Plan
Code

1

Accept
Qty

10

Reject
Qty

0

Reject
Number

102

Insp.
Stamp

130



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch 369

0.00

10-3-18 102

Memo

0.00

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Work Order Summary

Tuesday, May 22, 2012 12:55:52 PM

Page 1 of 1

Criteria : Work Order ID: 52709 Item ID: D212-725-1-929RevB Product Family PURCHASED ITEMS
 Work Order Start Dates 10/8/2009 to 10/8/2009 11:59:59 PM Work Order Required Dates 10/23/2009 to
 10/23/2009 11:59:59 PM
 All References
 Work Order Status Costed

Work Order ID	52709	Required Qty	10.0000	Status Code	Costed
Item ID	D212-725-1-929RevB	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	HOUSING ASS'Y				
Current Acct Value	\$57.280				
Start Date	10/8/2009	Required Date	10/23/2009	Completed Date	11/3/2011 8:38:25 AM
Standard		** Actual **		** Acct. Value **	** Variance **
<u>Direct Costs</u>	<u>Total</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>	<u>Each</u>
Material	\$213.050	\$0.000	\$57.280	\$57.280	100.00%
Labor	\$167.728	\$0.000	\$0.000	\$0.000	0.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$628.710	\$0.000	\$0.000	\$0.000	0.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$1,009.487	\$0.000	\$57.280	\$57.280	0.00%

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D212-725-1-143 Base Plate					
	10.0000		3/22/2010	10.0000	\$118.579
D212-725-1-145 Tube					
	10.0000		3/22/2010	10.0000	\$710.079
D212-725-1-147P Cup					
	10.0000		2/26/2010	10.0000	\$155.000
					Total Matl Amts: \$983.658

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
EWER01		10/13/2009										
130			0.00	0.00	0.00	0.00	1.00	\$0.000	\$0.000	\$0.000	\$0.000	\$0.000
		1/28/2010										
130			0.00	0.00	0.01	0.01	1.00	\$0.000	\$0.169	\$0.336	\$0.000	\$0.504
		4/27/2010										
130			0.00	0.00	0.50	0.50	1.00	\$0.000	\$10.130	\$15.195	\$0.000	\$25.325
	Total:		0.00	0.00	0.51	0.51	3.00	\$0.000	\$10.299	\$15.531	\$0.000	\$25.829

Tuesday, May 22, 2012 12:55:52 PM

Work Order Summary

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